

Date: Wednesday, 5/31/2006 7:39:52 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 27306					
Estimate Number	: 11041					
P.O. Number	: N/A			Part Number	: D2809	
This Issue	: 5/31/2006 S.O. No. : N/A			Drawing Number	: D2809 REV A1	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: A1	
Previous Run	: 25959			Material	: N/A	
Written By	: <i>Skyy Comment Below</i>			Due Date	: 6/20/2006	
Checked & Approved By	: <i>Off 06.05.31</i>			Qty:	50 Um: Each	
Comment	: Est C 02.03.07 Now turned in house NG					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0500	6061-T6 Round Bar .500"	
		Comment: Qty.: 0.1045 f(s)/Unit Total : 5.2238 f(s) 6061-T6 Round Bar .500" Material: 6061-T6 (QQ-A-250-11) rod .500"Ø	Batch: M19296 J.G 06/06/04
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA204	J.G 06/06/04 50
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.G 06/06/04 50
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	J.F. 06/06/04 50
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & deburr all sharp edges as per dwg	SAD 06/06/05 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: 

Date: 06/06/14

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Drawing Name: BUSHING

Job Number: 27306

Part Number: D2809

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DC 06/06/13

(50)

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder coat _____ per QSI 005 4.3

DC 06/06/13

(50)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57388

06/06/14 50

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/14 50

Job Completion



U 06.06.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

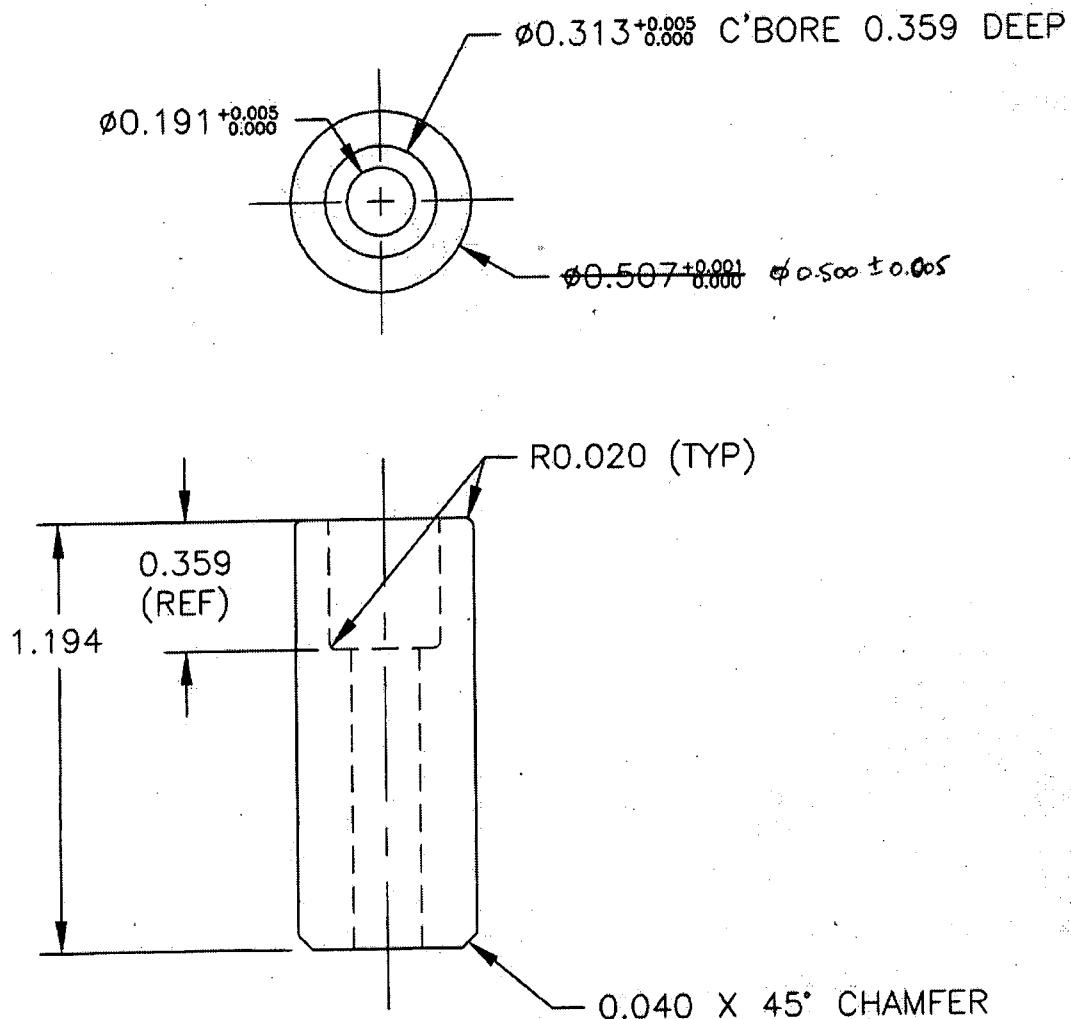
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
CP		D2809	SHEET 1 OF 1
DATE		TITLE	SCALE
00.11.07		SPACER	2:1
A	00.11.07	NEW ISSUE	
A1	CP 01.04.26	ADD POWDER COAT; $\phi 0.500$ wts $\phi 0.507$	

RELEASED
00.11.13 CP

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

OBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 27306

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020

MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

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